

**TECHNICAL DATA SHEET****SHORT DESCRIPTION:**

Although 480 Series is our “general purpose” ink, there is nothing ordinary or basic about it. This is a great ink for printing light to medium cotton and poly/cotton. Add an underbase and 480 Series will give you great coverage without that “blotchy” look you hate to see.

**QUICK SPECIFICATIONS:****MESH COUNT**  
86 to 230

This is simply a recommendation as your art work will determine exactly which mesh count is right for you. 480 Series will print through finer screen mesh if needed. When opacity is a concern, consider printing with 110 screen mesh.

**FLASH CURE**  
3/5: Average

The rating of **AVERAGE** implies a flash cure performance similar to most plastisol inks. Due to the great number of variables involved, we cannot specify a specific flash time or temperature. However, this ink should flash dry like most inks you have printed before.

**INK CURING**  
320°F to 330°F

Washing and drying your prints to check durability is the ultimate test of ink curing. However, the use of Thermolabels is the most sensible method of testing for your day-to-day operations. This will help you prevent cracking, peeling, and washout.

**SQUEEGEES**  
70 Durometer

Squeegees are one of many variables controlling your ink deposit. Softer squeegees are capable of printing thicker while hard squeegees allow for better print resolution. 60 durometer is soft. 70 durometer is medium. 80 durometer is hard.

**CLEAN UP**  
PW-4 or IR-26

Many cleaning products will remove plastisol ink. We recommend Saatchem PW-4 for cleaning on-press. The IR-26 is ideal when cleaning in a washout booth. Cleaning the ink out of the screen immediately after printing is always recommended.



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### 480 SERIES BENEFITS:

- Huge selection of colors.
- Best ink for wet-on-wet printing technique (add our WOW Additive for best results).
- Very creamy viscosity without being runny or thin.
- Much better coverage compared to competing general purpose inks.
- Soft hand feel.

### IDEAL CURING GUIDELINES:

Cure the 480 Series at the temperatures listed below (measure with a Thermolabel). Curing is a time and temperature process. A lower temperature with a slower belt speed is always the best method.

100% Cotton	Poly/Cotton	Polyester	Nylon/Stretch	100% Nylon	Polypropylene	Rayon
320°F	320°F	X	X	X	X	X

\*480 Series will adhere to 100% polyester fabrics. However, due to dye migration concerns we do not recommend 480 Series for use on 100% polyester. If the polyester fabric is white, print and cure the 480 Series inks to 320°F.

### TIPS AND TRICKS:

- Ask us for the WOW Additive for wet-on-wet screen printing. We will add it to your 480 Series color and it will be perfect for this technique.
- Although we do offer a 480 Series white ink, our best white ink for use with the 480 Series colors is Comfort FF White. This will flash faster, lay flatter, and feel softer on the fabric.
- If you get a blotchy appearance when printing colors such as medium royal or bears navy on a white underbase, check your ink deposit. It may not be thick enough to give you a smooth appearance.
- 480 Series inks are perfect for custom color matching. We can match Pantone® colors, ink swatches (wet or dry), heat press material, and even fabric.

Always perform a pretest print and test cure conditions on the fabric to be printed to establish the best results. Stir inks vigorously before each use. Viscosity may need adjusting for best results. If there is ever a question about a print job, call us at 800-942-4447. We are always happy to help!